



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200
Fax 613 632-5246

RB23007615
Job Sheet 184576



Part No: RB23007615

Job Qty: 1 pcs

Part Name: Power Turbine Support Cleaning C-30 & C-47



Part Weight: 0 lbs

Status: Scheduled

Priority: Medium

Job Created: 10/12/18

Job Tracking No:

Due Date: 11/12/18

Created By: Logan David

Type: SOLD

Description:

Note: DWG RB23007615 REV B IPP REV A 18.02.20 NEW ISSUE FK VERIFY DP

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup Hrs	Run Hrs	Workcenter / Supplier	Lead Time	
90	Start up Operation	1 Ea	11/12/18	11/12/18	0.00	0.00	Start Up Small Fab-4		
100	Small Fab - 1	1 pcs	11/12/18	11/12/18	0.00	0.00	Small Fab - 1		
							Small Fab - 2		
102	Small Fab - 2 - B4B	1 pcs	11/12/18	11/12/18	0.00	0.00	Small Fab - 1 - B4B		
							Small Fab - 2 - B4B		MLL
							Small Fab - 3 - B4B		
							Small Fab - 4 - B4B		
							Small Fab - 5 - B4B		
							Small Fab - 6 - B4B		
							Small Fab - 7 - B4B		
110	QC 5	1 pcs	11/12/18	11/12/18	0.00	0.00	QC 5 - 10		
							QC 5 - 12		
							QC 5 - 17		
							QC 5 - 18		
							QC 5 - 19		
							QC 5 - 22		
							QC 5 - 24		DAS
							QC 5 - 3		30
							QC 5 - 38		9-89
							QC 5 - 42		
							QC 5 - 43		
							QC 5 - 49		
							QC 5 - 51		
							QC 5 - 58		
							QC 5 - 68		
							QC 5 - 9		
							QC 5 - 50		
							QC 5 - 30		
130	Packaging 3-1 - Stock - B4B	1 pcs	11/12/18	11/12/18	0.00	0.00	Packaging3-2		
							Packaging 3 - 1 - B4B		
							Packaging 3 - 2 - B4B		

					Packaging 3 - 3 - B4B	
					Packaging 3 - 4 - B4B	
					Packaging 3 - 5 - B4B	
					Packaging 3 - 6 - B4B	
					Packaging 3 - 7 - B4B	
					Packaging 3 - 8 - B4B	
					Packaging 3 - 9 - B4B	
					Packaging 3 - 10 - B4B	MCC
					Packaging 3 - 11 - B4B	
					Packaging 3 - 12 - B4B	
					Packaging 3 - 13 - B4B	
					Packaging 3 - 14 - B4B	
					Packaging 3 - 15 - B4B	
					Packaging 3 - 16 - B4B	
					Packaging 3 - 17 - B4B	
					Packaging 3 - 18 - B4B	
					Packaging 3 - 19 - B4B	
					Packaging 3 - 20 - B4B	
					Packaging 3 - 21 - B4B	
					Packaging 3 - 22 - B4B	
					Packaging 3 - 23 - B4B	
					Packaging 3 - 24 - B4B	
					Packaging 3 - 25 - B4B	
					Packaging 3 - 26 - B4B	
					Packaging 3 - 27 - B4B	
					Packaging 3 - 28 - B4B	
					Packaging 3 - 29 - B4B	
					Packaging 3 - 30 - B4B	
					Packaging 3 - 31 - B4B	
					Packaging 3 - 32 - B4B	
					Packaging 3 - 33 - B4B	
					Packaging 3 - 34 - B4B	
					Packaging 3 - 35 - B4B	
					Packaging 3 - 36 - B4B	
140	QC 21 - FG	1 pcs	11/12/18	0.00 0.00	QC 21 - FG - 21	DAS 21 JAN 24 2019
					QC 21 - FG - 70	

Part Op **100** - Small Fab-9 (Small Fab) 1- Assemble as per DWG RB23007615 3- ***NOTE Red Barn sticker on sheet #7 N/A as Descriptions: per Eng.

110 - QC5 (QC5- Inspect part completeness to step on W/O)

130 - Packaging3-2 (Identify as per dwg & Stock Location:_____) Identify and Stock

140 - QC21 (QC21- Final Inspection - Work Order Release)

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
K206	Flambeau Plastic Box (Clean Out)	1 Ea (1 ea)	90-Start up Operation	
PAD210	Foam Ø1 X 1	.2220 sf (.222 ea)	90-Start up Operation	
RB23007615-11	#12 Drill Bit	1 Ea (1 ea)	90-Start up Operation	
RB23007615-13	Saw	1 pcs (1 ea)	90-Start up Operation	
RB23007615-15	Wire	4 ft (4 ea)	90-Start up Operation	
RB23007615-21	Guide	1 pcs (1 ea)	90-Start up Operation	
RB23007615-23	Socket Head Cap Screw	3 Ea (3 ea)	90-Start up Operation	
RB23007615-25	Strut Checking Gauge	1 pcs (1 ea)	90-Start up Operation	
RB23007615-3	#56 Drill Bit	1 Ea (1 ea)	90-Start up Operation	
RB23007615-5	#52 Drill Bit	1 Ea (1 ea)	90-Start up Operation	
RB23007615-7	#27 Drill Bit	1 Ea (1 ea)	90-Start up Operation	
RB23007615-9	#22 Drill Bit	1 Ea (1 ea)	90-Start up Operation	

Job Allocations				
Operation	Component Part	Required	Inventory	Allocated
90-Start up Operation	K206	1	21	0
	PAD210	0	11	0
	RB23007615-11	1	12	0
	RB23007615-13	1	15	0
	RB23007615-15	4	184	0
	RB23007615-21	1	19	0
	RB23007615-23	3	69	0
	RB23007615-25	1	12	0
	RB23007615-3	1	11	0
	RB23007615-5	1	9	0
	RB23007615-7	1	9	0
	RB23007615-9	1	13	0
Part Specifications				
Specifications could not be found.				

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RB23007615
Job Sheet 184576



Part No: RB23007615

Job Qty: 1 ea

Part Name: Power Turbine Support Cleaning C-30 & C-47



Part Weight: 0 lbs

Status: New

Priority: Medium

Job Created: 10/12/18

Job Tracking No:

Due Date: 11/12/18

Created By: Logan David

Type: SOLD

Description:

Note: DWG RB23007615 REV B IPP REV A 18.02.20 NEW ISSUE FK VERIFY DP

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup Hrs	Run Hrs	Workcenter / Supplier	Lead Time	
90	Start up Operation	1 Ea	11/12/18	11/12/18	0.00	0.00	Start Up Small Fab-4		
100	Small Fab	1 pcs	11/12/18	11/12/18	0.00	0.00	Small Fab-9		
110	QC	1 pcs	11/12/18	11/12/18	0.00	0.00	QC5		
130	Packaging	1 pcs	11/12/18	11/12/18	0.00	0.00	Packaging3-2		
140	QC21-FG	1 Ea	11/12/18	11/12/18	0.00	0.00	QC21		

Part Op 100 - 1- Assemble as per DWG RB23007615 3- ***NOTE Red Barn sticker on sheet #7 N/A as per Eng.
Descriptions: 130 - Identify and Stock

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
K206	Flambeau Plastic Box (Clean Out)	1 Ea (1 ea)	90-Start up Operation	5127655
PAD210	Foam Ø1 X 1	.2220 sf (.222 ea)	90-Start up Operation	5021250
RB23007615-11	#12 Drill Bit	1 Ea (1 ea)	90-Start up Operation	5144373
RB23007615-13	Saw	1 Ea (1 ea)	90-Start up Operation	5141755
RB23007615-15	Wire	4 ft (4 ea)	90-Start up Operation	5097885
RB23007615-21	Guide	1 Ea (1 ea)	90-Start up Operation	5141679
RB23007615-23	Socket Head Cap Screw	3 Ea (3 ea)	90-Start up Operation	5144310
RB23007615-25	Strut Checking Gauge	1 Ea (1 ea)	90-Start up Operation	5096428
RB23007615-3	#56 Drill Bit	1 Ea (1 ea)	90-Start up Operation	5144369
RB23007615-5	#52 Drill Bit	1 Ea (1 ea)	90-Start up Operation	5144370
RB23007615-7	#27 Drill Bit	1 Ea (1 ea)	90-Start up Operation	5144371
RB23007615-9	#22 Drill Bit	1 Ea (1 ea)	90-Start up Operation	5119743



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Container No: S147550



Part: RB23007615

Job No: 184576

Serial No/Batch: S147550

Revision: B

Inspector:

Exp Date:

Instructions:

Date: 01/24/19

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Job Allocations				
Operation	Component Part	Required	Inventory	Allocated
90-Start up Operation	K206	1	22	0
	PAD210	0	12	0
	RB23007615-11	1	4	0
	RB23007615-13	1	16	0
	RB23007615-15	4	188	0
	RB23007615-21	1	20	0
	RB23007615-23	3	22	0
	RB23007615-25	1	13	0
	RB23007615-3	1	0	0
	RB23007615-5	1	0	0
	RB23007615-7	1	0	0
	RB23007615-9	1	4	0
Part Specifications				
Specifications could not be found.				

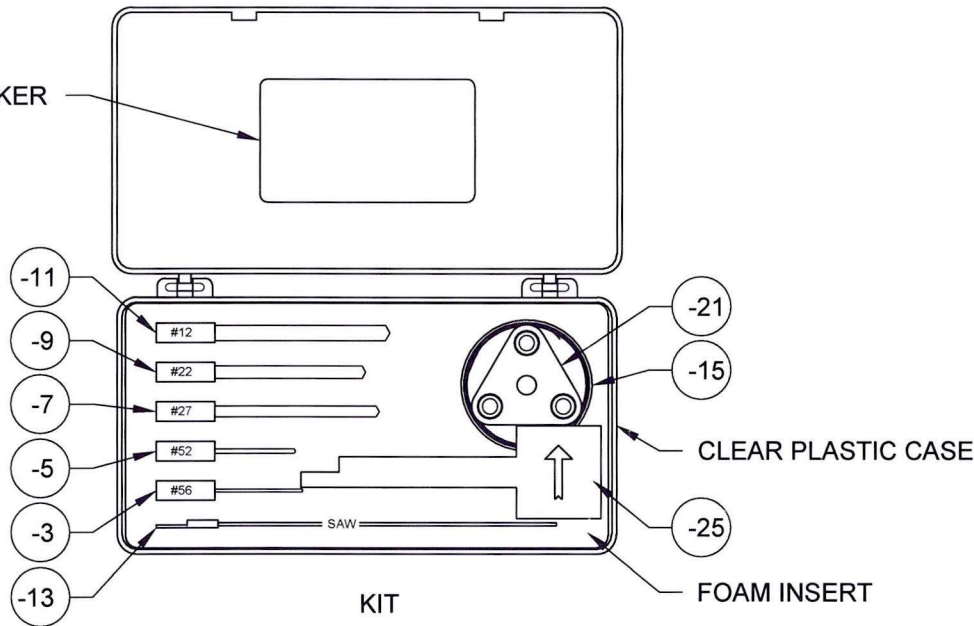
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REVISIONS				
REV	DESCRIPTION	DATE	INITIAL	APPROVED
A	CH'D TITLEBLOCK & REVISION BLOCK, ADDED DWG'S FOR CASE, FOAM INSERT, & ASSY.	8/11/09	RJC	RW
B	-2 ADDED NOTES TO SHEET. -13, -21, -23 MOVED TO SEPARATE SHEETS. -13 CH'D DIMS WAS 6.000 IS 6.00, WAS 12.000 IS 12.00. -21 CH'D DIMS WAS R.300 X3 IS 3X R.30, WAS DRILL & TAP 1/4-28 UNF X3 IS 3X 1/4-28 THRU. ADDED MISSING DIM 2X .344.	2/3/14	DPD	RJC

TEO ATTACHED

RED BARN STICKER



ASSY QTY	ASSY QTY	B/O	PART #	UNIT QTY	DESCRIPTION	MATERIAL	B/O INFORMATION OR SPECIFICATIONS	Pg.
			-2	5	BLOCK	6061	5/16 HEX x 1	2
			-3	1	#56 DRILL BIT		SEE -2 -56 FOR BLOCK METHODS	2
			-5	1	#52 DRILL BIT		SEE -2 -52 FOR BLOCK METHODS	2
			-7	1	#27 DRILL BIT		SEE -2 -27 FOR BLOCK METHODS	2
			-9	1	#22 DRILL BIT		SEE -2 -22 FOR BLOCK METHODS	2
			-11	1	#12 DRILL BIT		SEE -2 -12 FOR BLOCK METHODS	2
			-13	1	SAW		6" LENGTH #HAC5012BX (BESTWAY PRODUCTS)	3
							.050 ROUND x 6 SECTION	
B/O		-15	4'	WIRE			.041 WRAPPED AROUND 1-7/8 ARBOR	1
		-21	1	GUIDE	6061		Ø2 x 1-1/16	4
		-23	3	SOCKET HEAD CAP SCREWS	STEEL		1/4-28 UNF x 3/8 MODIFIED MCMaster-CARR #91251A435	5
		-25	1	STRUT CHECKING GAGE	6061		.05 x 4-7/8 x 1-1/2	6
B/O			1	CLEAR PLASTIC CASE			FLAMBEAU #K206 OR EQUIV.	7
B/O			1	CRAFT FOAM			1 x 4 x 8	7
B/O			1	RED BARN STICKER			STICKER FACE INSIDE LID FACING OUT	7

RED BARN MACHINE	
TITLE POWER TURBINE CLEANING KIT	
DWG NO. RB23007615	REV B
UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES	
TOLERANCES ON:	DRAWN BY: CLOUGH
DECIMALS .XXX ± .005	APPROVED <i>D. Weil</i>
XX ± .01	HEAT TREAT
.X ± .1	FINISH SPEC
FRACTIONS ± 1/32	
ANGLES ± 5°	
UNLESS OTHERWISE SPECIFIED 1. BREAK ALL SHARP EDGES .015 x 45° PR .015 R	
2. DIMENSIONAL LIMITS APPLY AFTER PLATING	
SCALE 1:3	DATE 2-1-01
SHEET 1 of 7	